

Work Order ID 85048

85048

Page 1

May-31-12 3:41:04 PM

Item ID: D4108-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Template

Start Date: 31/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/01*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4108

B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1-Cut as per Dwg

2-Deburr if necessary

8

FF
12-06-20

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

8

12-06-21

130

Identify as per dwg & Stock Location: *ST 96*

0.00

130

Packaging

Memo

0.00

Packaging

8x

8P
12-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85048

May-31-12 3:41:04 PM

85048

Page 2

Item ID: D4108-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Template

Start Date: 31/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/2598
MLJ 12/06/21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-31-12 3:41:08 PM

Page 1

Work Order ID: 85048

85048

Parent Item: D4108-11

D4108-11

Parent Item Name: Template

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC
10.12.03 as per dwg rev.B DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.060-9034-08		Purchased			No	100	sf	25.9184	0.02888	0.1824			

MI FXS 060-9034-08
.060" 9034 Lexan Sheet

**

8

FF
12-06-20

Location

Loc Qty

Loc Code

MAT020

7.54

115569

7.54

therm

18.3784

117339

18.3784

~~0.1824~~
0.23104

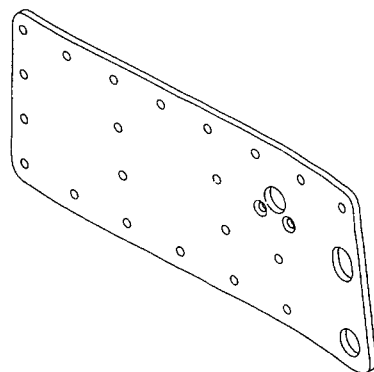
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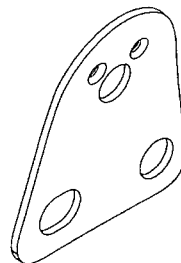
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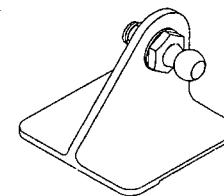
NOTE: Date & initial all entries



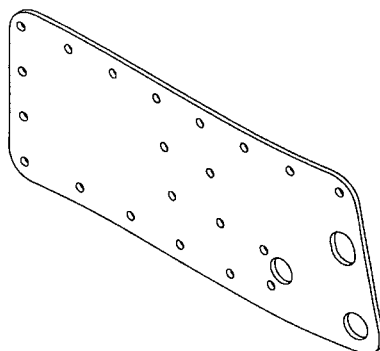
D4108-1 LEFT PASS DOOR DOUBLER



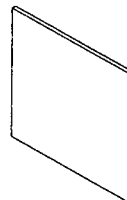
D4108-5 SMALL RIGHT DOOR DOUBLER



D4108-047 SILL BRACKET ASSEMBLY

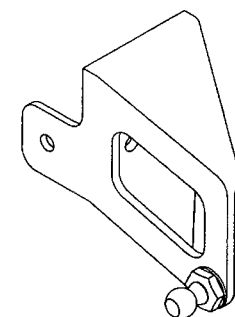


D4108-3 RIGHT PASS DOOR DOUBLER



D4108-11 TEMPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85048 MJS



D4108-049 LITTER DOOR FITTING ASSEMBLY

RELEASED
2010-11-30

B	D4108-5 (ZN C4-1 & 84-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 6061-T6 AL. NOTES UPDATED (SHT 5,6)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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2010-11-30
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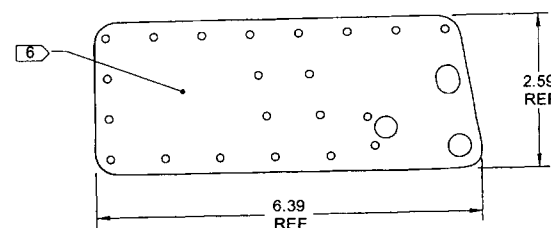
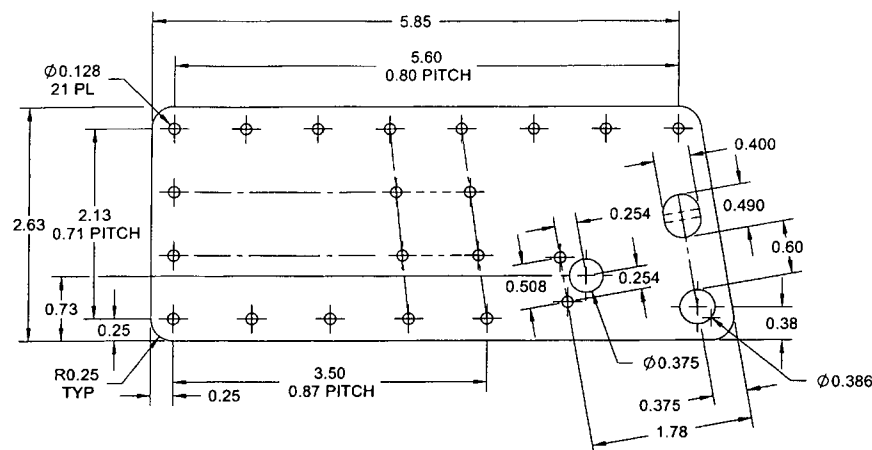
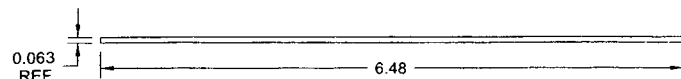
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8507/8



D4108-3 RIGHT PASS DOOR DOUBLER (MAKE FROM D4108-3F)

D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER

NOTES:

- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-3 : MAKE FROM D4108-3F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9649:

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2010-11-30
WJ

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4108	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 7	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
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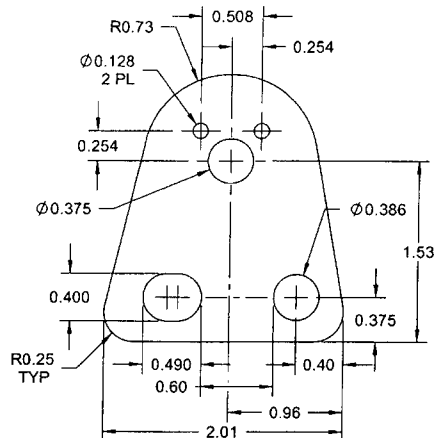
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

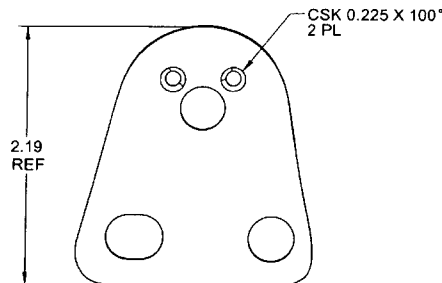
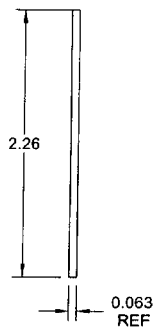
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

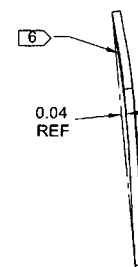
NOTE: Date & initial all entries



D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER



D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)



- NOTES:**
- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-5: MAKE FROM D4108-5F.
 - 2) FINISH: NONE.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
 - 7) WEIGHT: 0.06 lbs
 - 8) FORM & INSPECT PER TEMPLATE DT9649.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4108	REV. B
MFG. APPR.	JPH	SHEET 4 OF 7	
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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2010-11-30
ND

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

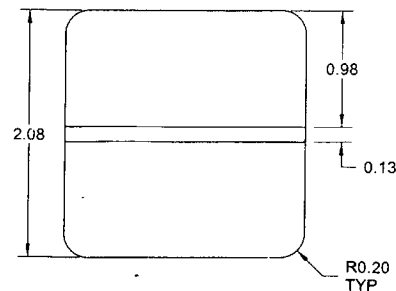
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

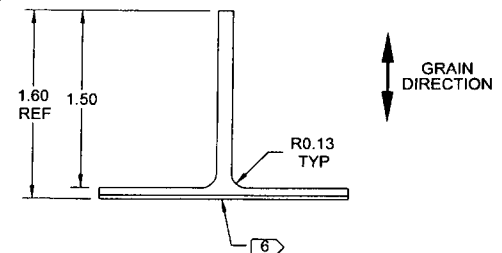
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85048.



D4108-7 BRACKET



RELEASED
2010-11-30
AM

- NOTES:**
- (B)** 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- (B)** 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
- (B)** 7) WEIGHT -047: 0.10 lbs
8) TORQUE TO 5-10 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>g3</i>	DRAWING NO. D4108	REV. B
MFG. APPR.	<i>g3</i>		SHEET 5 OF 7
APPROVED	<i>g3</i>		SCALE
QE APPR.	<i>#1</i>		NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

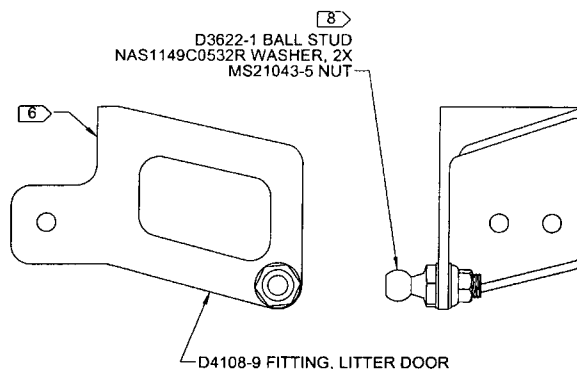
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

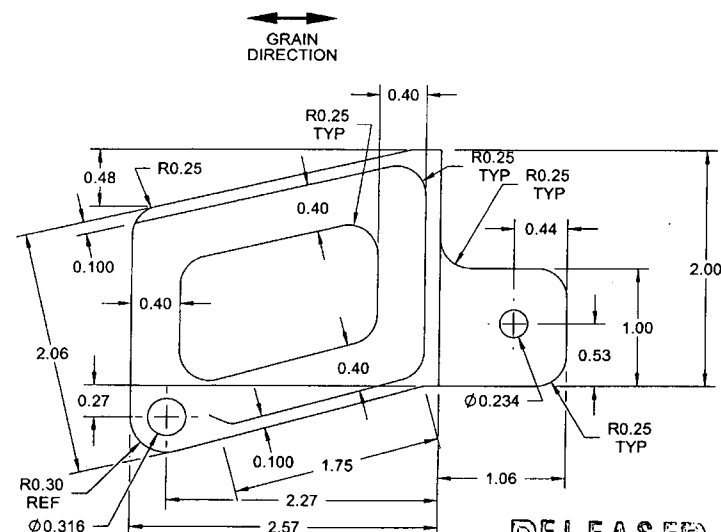
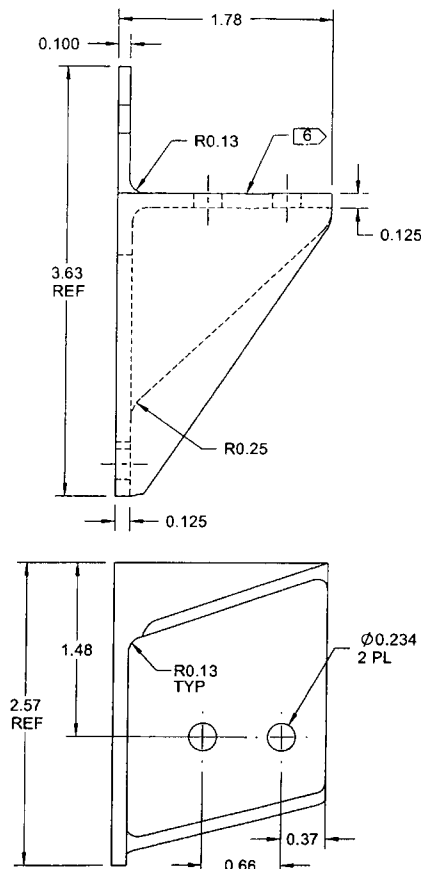
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Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY



D4108-9 FITTING, LITTER DOOR

NOTES:

- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
- 7) WEIGHT -049: 0.19 lbs
- 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 6 OF 7
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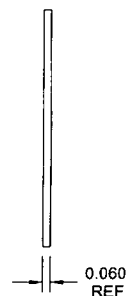
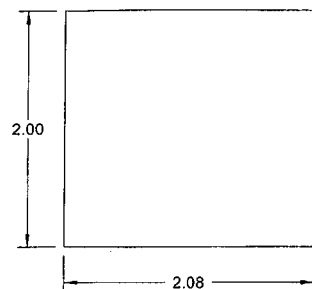
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NOTE: Date & initial all entries

85042



D4108-11 TEMPLATE

RELEASED
2010-11-30
NR

NOTES:

1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060

2) FINISH: NONE



3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1

7) WEIGHT: N/A

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
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